



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3488-4

Job Sheet 189482



Part No: D3488-4

Job Qty: 5 pcs

Part Name: Blade Fitting, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/25/19

Job Tracking No:

Due Date: 2/7/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DSK101 REV.D / D3488 REV.C IPP REV:A 18.11.09 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	5		2/7/19	0.00	4.39	Doosan - 1		
		pcs							
110	QC 2	5		2/7/19	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S148185



Part: D3488 - 4

Job No: 189482

Serial No/Batch: S148185

Revision: D/C

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Date: 01/25/19

120 HAAS 4 Axis - B4B	5 pcs	2/7/19	0.11 3.43	QC 2 - 8	
				HAAS - 1 - B4B	
				HAAS - 2 - B4B	
				HAAS - 3 - B4B	SBL / MK 19/01/31
				HAAS - 4 - B4B	
130 QC 2	5 pcs	2/7/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	MK 19/01/31
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 38	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
140 QC 8	5 pcs	2/7/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	MK 19/02/06
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
150 Handfinish - 1-1 Chemical- B4B	5 pcs	2/7/19	0.00 0.15	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	

				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/12/17
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 Powdercoat - 1 White Gl(A)- B4B	5 pcs	2/7/19	0.00 0.18	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	BEB 19-02-07
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
170 QC 3	5 pcs	2/7/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	JSK 19-2-8
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
200 Packaging 3-1 - Stock - B4B	5 pcs	2/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	

DAS
15
9-89

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP 001 14-2-9
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	5	2/7/19	0.00 0.00	QC 21 - SA - 21	DAG 21
	pcs			QC 21 - SA - 70	9-55 FEB 08 2019
Part Op 100 - Doosan (Doosan Lathe) 1-Turn as per Dwg DSK 101 & Folio FC492 Descriptions: 110 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB) 120 - HAAS1-3 (HAAS CNC Vertical Machine) 1-Machine as per Folio FA627 & Dwg D3488 130 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB) 140 - QC8 Machining-2 (QC8- Inspect parts - second check) 150 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1) M138997. 160 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 9:20 FINISH TIME: 9:50 OVEN TEMPERATURE: 320 170 - QC3 (QC3- Inspect Part Finish) 200 - Packaging3-1 (Identify as per dwg & Stock Location: LOCATION : FP001) 210 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6103-003	Round Billet, Aluminum	5 pcs (1 ea)	100-Doosan - 1	S141243 X3 S127085 X2	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	D6103-003	5	20	0	
Part Specifications					
Specifications could not be found.					

DART AEROSPACE LTD	Work Order:	189482
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number:	D3488-24
Inspection Dwg: D3488 / DSK101 Rev: C / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.151				
Ø2.780	+/-0.005	2.779				
Ø3.125	+/-0.010	3.1235				
Ø3.346	+/-0.010	3.346				
0.125 x 45°	+/-0.010 x +/-0.1°	0.120 x 45				
8.000	+0.030/-0.000	8.010				
9.250	+/-0.010	9.251				
0.188	+/-0.010	0.188				
R0.032	+/-0.010	R0.032				
R0.062	+/-0.010	R0.062				
Ø0.297	+0.005/-0.001					
Ø0.430	+/-0.010					
0.100	+/-0.010					
0.200	+/-0.010	0.198				
2.620	+/-0.010	2.619				
3.500	+/-0.010					
1.005	+/-0.010					
Ø0.484	+0.005/-0.001	0.487				
1.180	+/-0.010	1.18				
3.150	+/-0.010	3.15				
3.070	+/-0.010	3.066				
R0.063	+/-0.010	R0.063				

DART AEROSPACE LTD		Work Order: 189482
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number: D3488-24
Inspection Dwg: D3488 / DSK101 Rev: C / D		Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	.508	✓			
0.750	+/-0.010	.750	✓			
1.500	+/-0.010	1.500	✓			
11.18	+/-0.030	11.18	✓			
R0.062	+/-0.010	.062	✓			
0.125	+/-0.010	.125	✓			
0.590	+/-0.010	.597	✓			
0.793	+/-0.010	.798	✓			
1.351	+/-0.010	1.345	✓			
1.317	+/-0.010	1.317	✓			
1.802	+/-0.010	1.802	✓			

Measured by: DLSBL/ML	Audited by: mmc	Prototype Approval:	N/A
Date: 19/01/25 / 19/01/26	Date: 17/02/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-042	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	
D	18.11.22	Dimension 0.125 changed to 0.200	MG	ML